

Work Order ID 83347

83347

Page 1

April-17-12 2:18:11 PM

Item ID: K10111

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Skidtube 206

Stop *NS2*

Start Date: 17/04/2012 Start Qty: 4.00 ³

4

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9583

A

K10111

B

100

0.00

DAS 16 2/26/13

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP
FOR D206-642-111 CHG007
FOR D206-642-113 CHG002

K10111 CHG003

JB

for MLJ 12-7-31

(3)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3

12/08/01 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83347

April-17-12 2:18:11 PM

83347

Page 2

Item ID: K10111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K10111

PPP D206-642-111

PPP D206-642-113

Location:

PPP rev:

PAN 88707 80918 80977

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/8/13 (B)

12/8/17

MLJ 12/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

April-17-12 2:18:15 PM

Page 1

Work Order ID: 83347

83347

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: F01.11.08 Revised Step 5 and Added Inspection Level

2ISM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

IPP REV:H 11.11.14

AS PER DS19583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A

Purchased

No

110

Each

617.0000

8

32 24

**

AN3-41A

Bolt

Location

Loc Qty

Loc Code

ST335

67

120644

67

ST354

550

120498

200

121162

150

121243

200

121162

AN4-6A

Purchased

No

110

Each

1,635.000

12

48 36

**

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

1635

119017

1135

121243

500

13 119017

AN4C5A

Purchased

No

110

Each

235.0000

1

43

**

AN4C5A

BOLT

Location

Loc Qty

Loc Code

ST355

235

112243

152

119017

83

119017

12/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 83347

83347

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN5-10A

Purchased

No

110

Each

374.0000

S₇₃ *AN5-10A*
Bolt

** 4 1612 ✓
122151 JB

Location

Loc Qty

Loc Code

ST337

374

118191

80

120630

14

120717

50

120770

80

121181

50

121243

100

Purchased

No

110

Each

617.0000

S₇₃ AN5-11A
AN5-11A
Bolt

** 4 1612 ✓
JB

Location

Loc Qty

Loc Code

ST337

617

118191

13

119512

604

Purchased

No

110

Each

79.0000

S₇₃ AN6-44A
AN6-44A
Bolt

** 2 119512
86 ✓
JB 12/08/01

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

72

119036

72

119036

April-17-12 2:18:15 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 83347

83347

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

D206-651-041

Manufactured No

110 Each

7.0000

D206-651-041

206A/B GHW

CHL501

Location

Loc Qty

Loc Code

FG120

7

79558

7

D2652

Manufactured No

110 Each

172.0000

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

128

73836

36

77134

15

77136

77

D2661-1

Manufactured No

110 Each

8.0000

D2661-1

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST434

1

80412

1

D2662-1

Manufactured No

110 Each

4.0000

D2662-1

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

4

80414

4

0 43

**

1X 85507

2X 83042

06

64 48 ✓

**

33X 86894 JB

15X 83252

2

86 ✓

**

80989 JB

2

86 ✓

**

80991 JB

12/08/01

April-17-12 2:18:16 PM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 4

Work Order ID: 83347

83347

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

D2712

Manufactured No

110 Each

697.0000

10

40 30 ✓

D2712

Set Screw

**

83559

JB

✓

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

647

79585

447

81871

200

D2884

Manufactured No

110 Each

97.0000

2

84 -

D2884

Saddle Spacer

**

JB

✓

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

87

76751

87

D2885

Manufactured No

110 Each

88.0000

2

84 -

D2885

Saddle Spacer

**

JB

12/08/01

✓

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

78

76752

78

76752

April-17-12 2:18:16 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 5

Work Order ID: 83347

Parent Item: K10111

Parent Item Name: Saddle, Skidtube 206

83347

K10111

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110 Each

48.0000

D3413-1
Ring

**

43 ✓
87253 JB

Location

Loc Qty

Loc Code

ST420

16

79233

16

ST464

32

76754

22

80224

10

MS21042L3

Purchased No

110 Each

2,891.000

MS21042L3
Nut

**

3224 ✓
122141 JB

Location

Loc Qty

Loc Code

ST300

2891

117441

16

117885

32

118451

5

118927

3

119017

1677

119075

158

121349

1000

MS21042L4

Purchased No

110 Each

3,495.000

MS21042L4
Nut

**

4836 ✓
121444 JB

12/08/01

Location

Loc Qty

Loc Code

ST300

3495

116188

5

119017

4

119075

1486

121011

2000

April-17-12 2:18:16 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-17-12 2:18:16 PM

Page 6

Work Order ID: 83347

83347

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

110

Each

758.0000

MS21042L6

Nut

** 2 86 -

JB

Location

Loc Qty

Loc Code

ST300

758

117677

25

118384

3

118927

48

119075

482

120308

200

119075

NAS1149C0463R

Purchased

No

110

Each

964.0000

NAS1149C0463R

Washer

** 43

JB

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

963

117735

25

119097

938

119097

NAS1149D0363J

Purchased

No

110

Each

2,279.000

NAS1149D0363J

Washer

** 8 3224 ✓

121524

JB

12/08/01

Location

Loc Qty

Loc Code

ST298

2279

117601

61

118077

1

118612

18

119537

33

120142

76

120308

46

120644

256

121243

1788

April-17-12 2:18:16 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-17-12 2:18:16 PM

Page 7

Work Order ID: 83347

Parent Item: K10111

Parent Item Name: Saddle, Skidtube 206

83347

K10111

NAS1149D0463J

Purchased

No

110

Each

4,975.000

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463.I

Washer

**

96 72 ✓
122441 JB

Location

Loc Qty

Loc Code

ST297

694

121011

694

ST298

4281

116805

0

117065

8

118384

5

119097

97

121255

4171

NAS1149D0563J

Purchased

No

110

Each

4,378.000

NAS1149D0563.I

Washer

**

32 24 ✓
JB

Location

Loc Qty

Loc Code

ST298

4378

118206

18

118614

246

119546

2000

119717

114

121255

2000

NAS1149D0663J

Purchased

No

110

Each

643.0000

NAS1149D0663.I

Washer

**

4612 ✓
121708 JB 12/07/31

Location

Loc Qty

Loc Code

ST298

643

120644

143

121243

500

April-17-12 2:18:17 PM

Shop Packet Print

Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83347 MJS
12/04/17

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	KENT, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	140	TITLE	SCALE
DE APPR.	TH	BOLT SUBSTITUTION	NTS
DATE	11.11.02	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	140	DRAWING NO.	REV. C
MFG. APPR.	BE	K10111	SHEET 1 OF 1
APPROVED	140	TITLE	SCALE
DE APPR.	TH	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	